

Date: Thursday, 3/9/2006 9:23:12 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 26187		
Estimate Number	: 10749		
P.O. Number	: N/A	Part Number	: D33154
This Issue	: 3/9/2006	Drawing Number	: D3315 REV. A PRELIM 05.03.03 PH
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A B 05.03.03 PH
Previous Run	: 24704	Material	: N/A
	Type : PURCHASED PARTS	Due Date	: 3/16/2006
Written By	: SEE COMMENT BELOW	Qty:	5 Um: Each
Checked & Approved By	: SEE ABOVE DATE & USER		
Comment	: Est: A 05.05.12 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 521

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3315

Possible Supplier: Industrial Laser

Material release note is required

L 06.02.06

(5)

2.0	D33154F	Wearplate Flat Pattern
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

WEARPLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C 206/02/22 (5)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per inspection template D3315-4T1

PH 06.03.03

(5)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

PB 06.03.03

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 9:23:12 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 26187

Part Number: D33154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

AB 06-03-09 (5)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev: B

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

Batch
M19682

CPL 06-03-15 (5)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/03/16 (4)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/03/20 (3)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ML 06-03-21 (4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-4, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: _____

PDA05-17 PH 06-03-09

06/3/21 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-14	8	Took 1 D 3315-4 wear plate to make D3315-4T3 welding template Inspected by <i>[Signature]</i> 06-03-14	CPL	06-03-14	1	<i>[Signature]</i> 06-03-14	<i>[Signature]</i> 06-03-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/03/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 9:23:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 26187

Part Number: D33154

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(4)

06/03/22

Job Completion



11 06-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

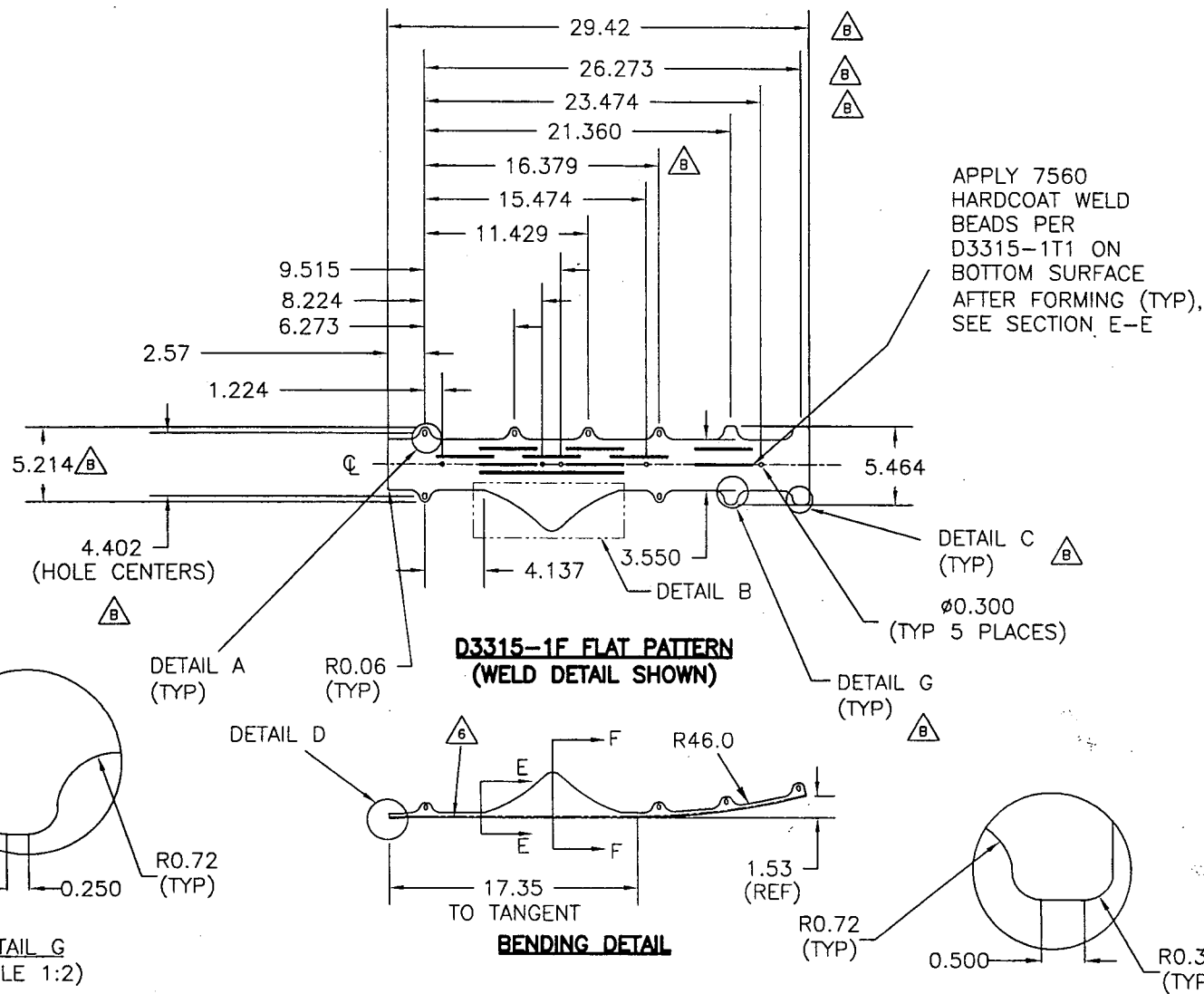
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.01.31



**D3315-1F FLAT PATTERN
(WELD DETAIL SHOWN)**

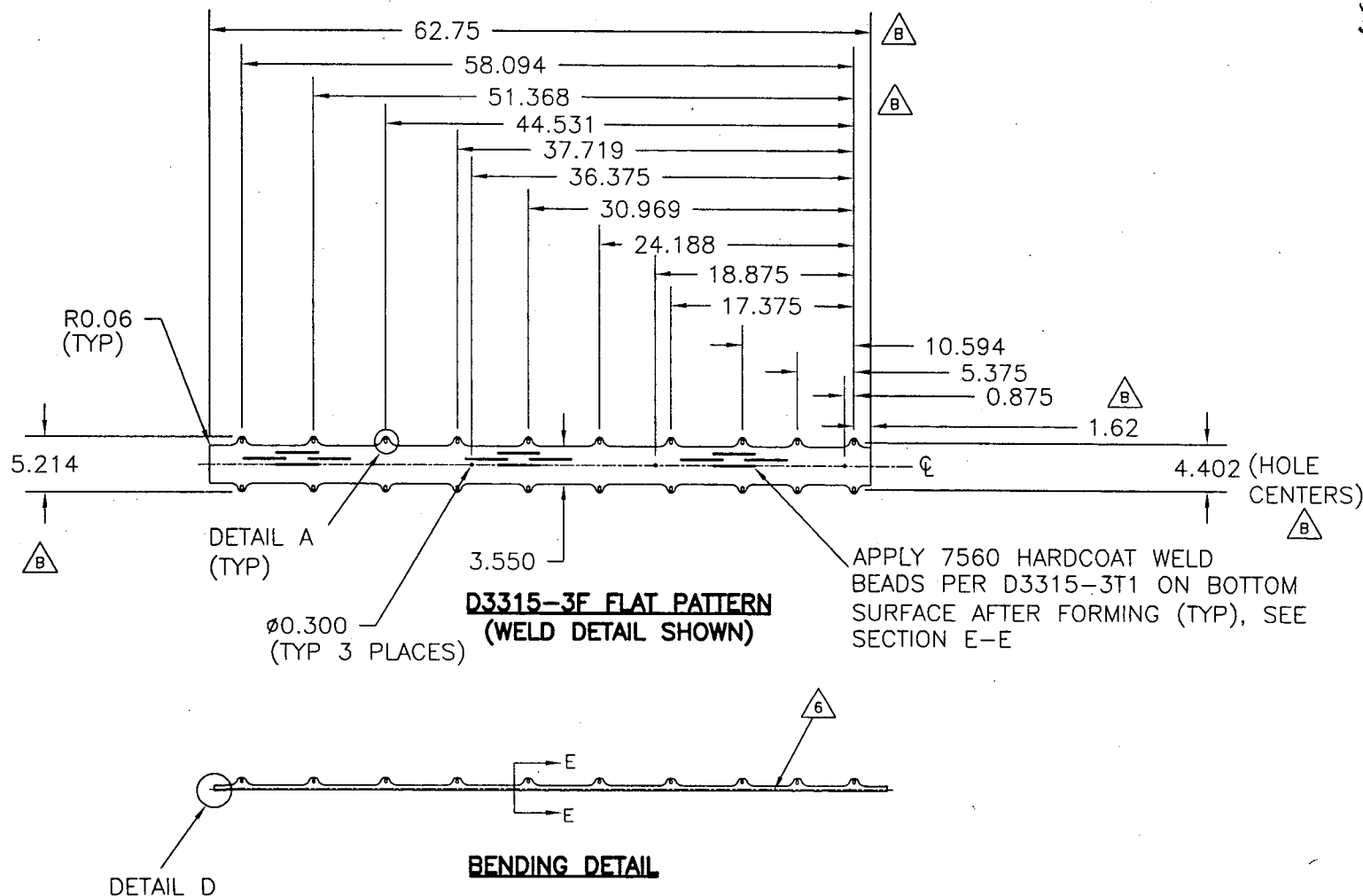
BENDING DETAIL

D3315-1 WEARPLATE (SHOWN, -2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE 'PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3315
DATE 06.01.31	TITLE WEARPLATE	REV. B
A	04.09.10	NEW ISSUE
B	06.01.31	UPDATE DIMENSIONS
SCALE 1:12	SHEET 1 OF 4	

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.01.31



**D3315-3F FLAT PATTERN
(WELD DETAIL SHOWN)**

BENDING DETAIL

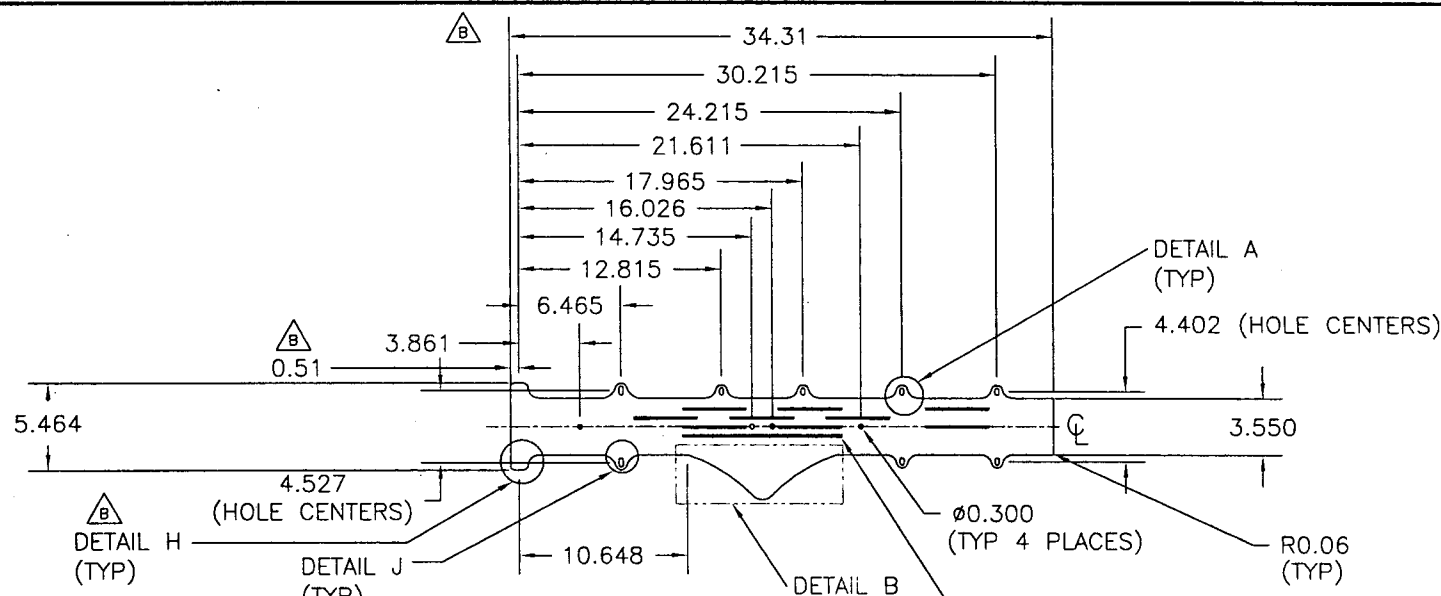
D3315-3 WEARPLATE (SHOWN, -4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
06.01.31	D3315	SHEET 2 OF 4
	TITLE	SCALE
	WEARPLATE	1:16

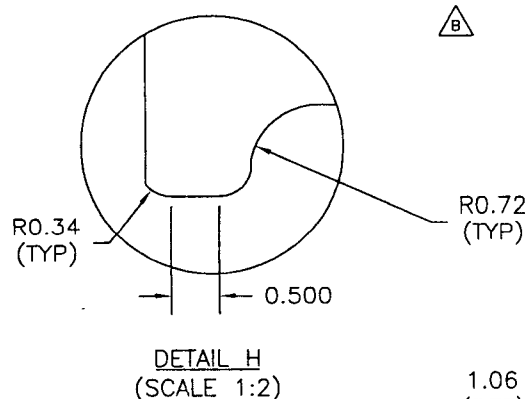
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.02.37 #4

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
06.01.31	D3315	SHEET 3 OF 4
	TITLE	SCALE
	WEARPLATE	1:12



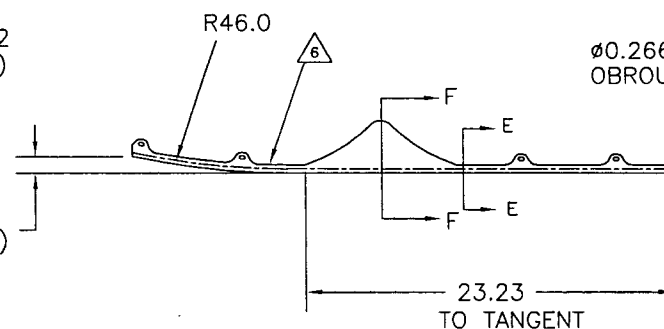
D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E

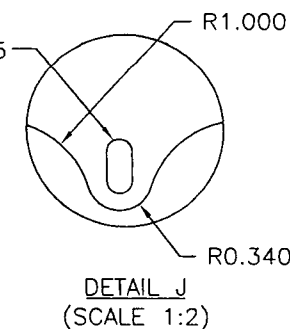


R0.72
(TYP)

1.06
(REF)



BENDING DETAIL



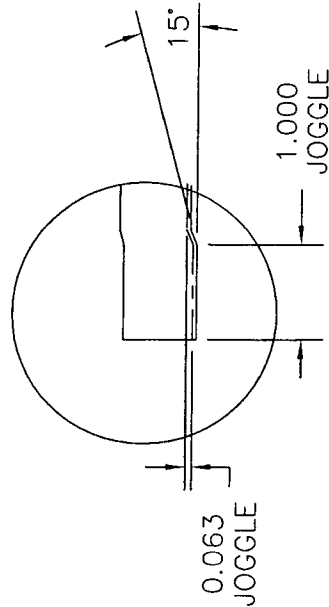
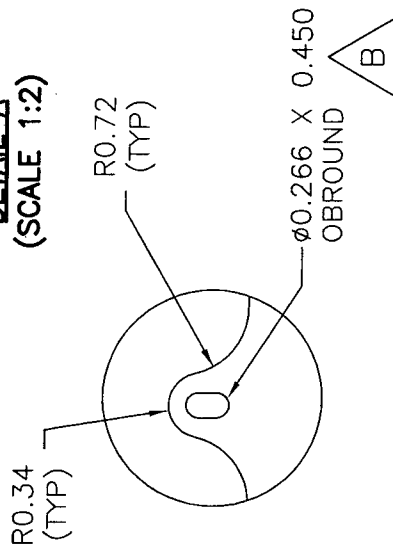
D3315-5 WEARPLATE (SHOWN, -6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

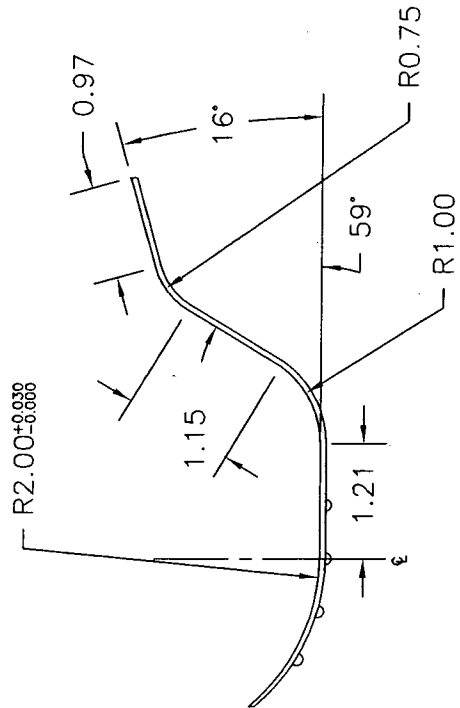
PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 05.02.27 PH

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

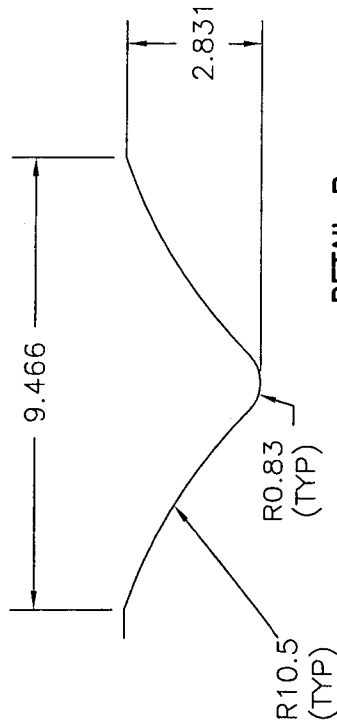
DETAIL A
(SCALE 1:2)



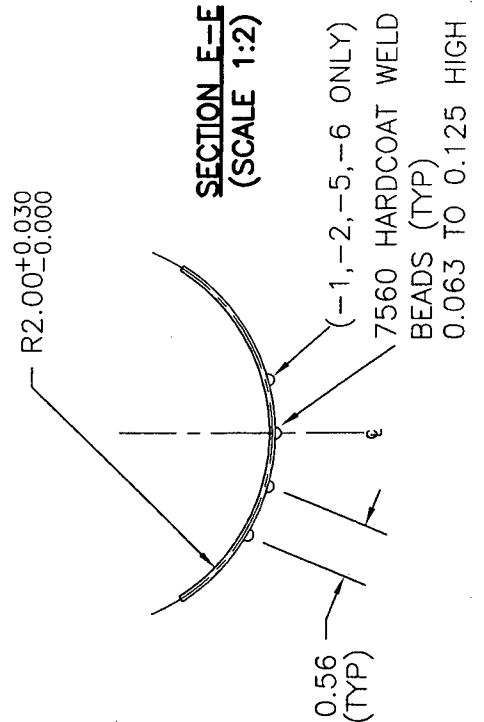
DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



DETAIL B
(SCALE 1:4)



SECTION E-E
(SCALE 1:2)

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